

Work Order ID 54382

December 8, 2009 11:28:28 AM

Page 1

Item ID: D3766-2

Accept



Setup Start



Revision ID:

Item Name: Front Rail, RH

Stop



Start Date: 08/12/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *RL*Date: *08/12/09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3766	Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3766 2-drill holes thru to finish size as per dwg D3766 using DT9413, drill holes labelled #2 3- deburr

RL 10/01/06

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Small Fab

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

RL 10/01/11

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3766-2 PAR #: N/A Fault Category: Sm Bl Fr B NCR: Yes No DQA: H Date: 10.01.12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: H Date: 10/01/26

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/12/19	100	After drilling, it was found on Qty x4 parts that the holes at section E E. Do not align with the sleeve D3762-3.	Initial Foster	- Parts do not align so scrap Qty x4 and replace PA j13511	M-F 10/01/05	S 10/01/05	Initial Foster	S 01/12/09
		24 improper training on drill Jig. Lack of communication	Initial Foster	- Lead hand must train all employees in cell to be able to work with all Jigs; record on Job training logs; attach ref copy.	S 10/01/12	S 10/01/12	Initial Foster	S 01/12/09

NOTE: Date & initial all entries

Work Order ID 54382

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Page 2

Item ID: D3766-2

Accept



Setup

Start



Revision ID:

Item Name: Front Rail, RH

Step



Start Date: 08/12/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-1-11 81/104

140

Identify as per dwg & Stock Location: 254

0.00



Packaging

Memo

0.00

Packaging

10-1-12 51/100

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/2009

MF 10-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 11:28:32 AM

Page 1

Work Order ID: 54382



Parent Item: D3766-2



Parent Item Name: Front Rail, RH

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	56.1948	29.3968			

6061T6 RD TUBE 1.00 X .188W



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	56.1947542
109041	1.03
112529	53.5647542
18101	1.6

m-h 10/01/05

10X

M113S11

X

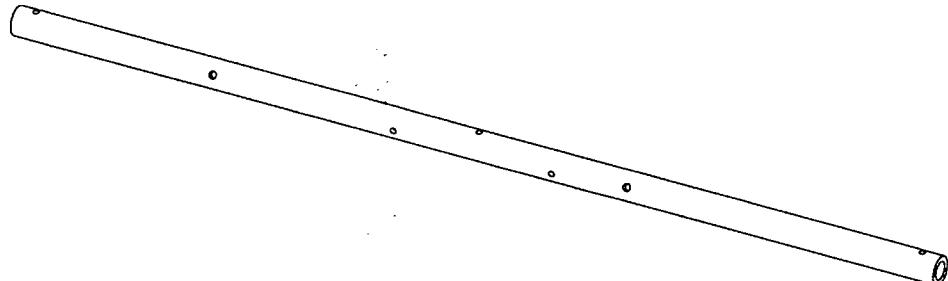
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

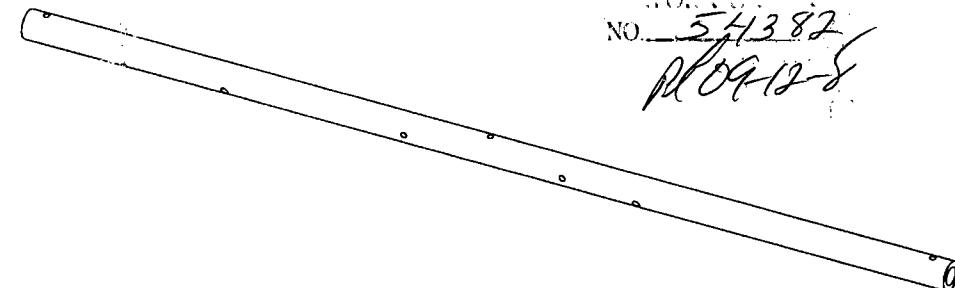
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

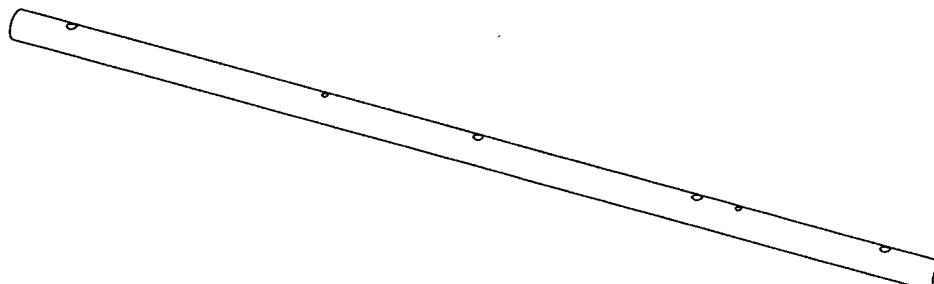
NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH



D3766-2 FRONT RAIL, RH



D3766-3 REAR RAIL

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

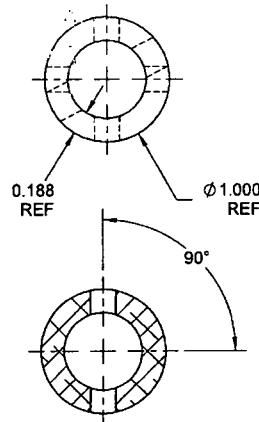
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NO. 54382
PL 09/12/8

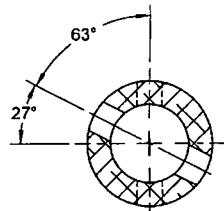
08.07.10 MTP

B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125		HS	08.06.10
A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD		
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	RJ	DRAWING NO.	REV. B	
MFG. APPR.		D3766		SHEET 1 OF 4
APPROVED	MD	TITLE	SCALE	
DE APPR.		RAIL	NTS	
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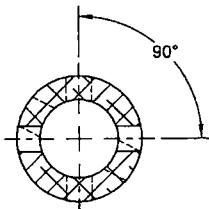
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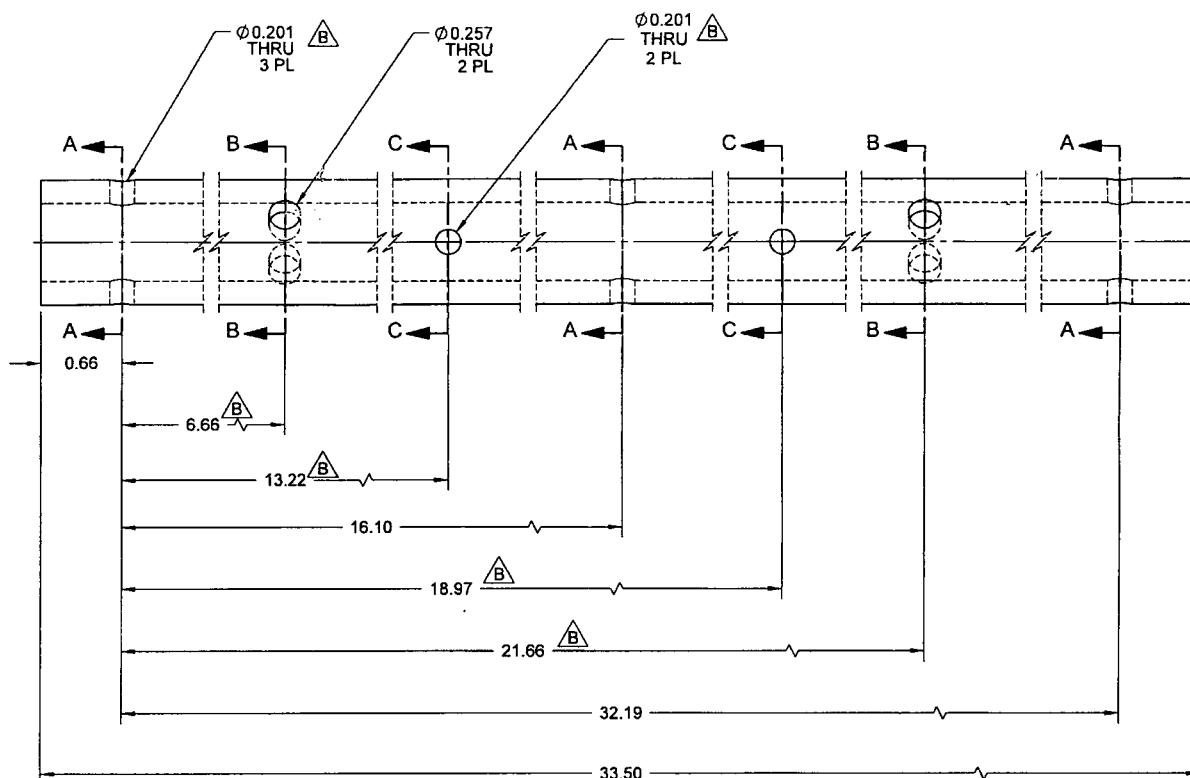
SECTION A-A



SECTION B-B



SECTION C-C



D3766-1 FRONT RAIL, LH

RELEASED
08-07-10 MFD

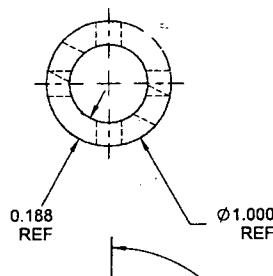
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APPROVED	✓	SHEET 2 OF 4	
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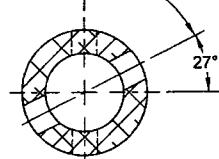
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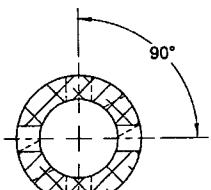
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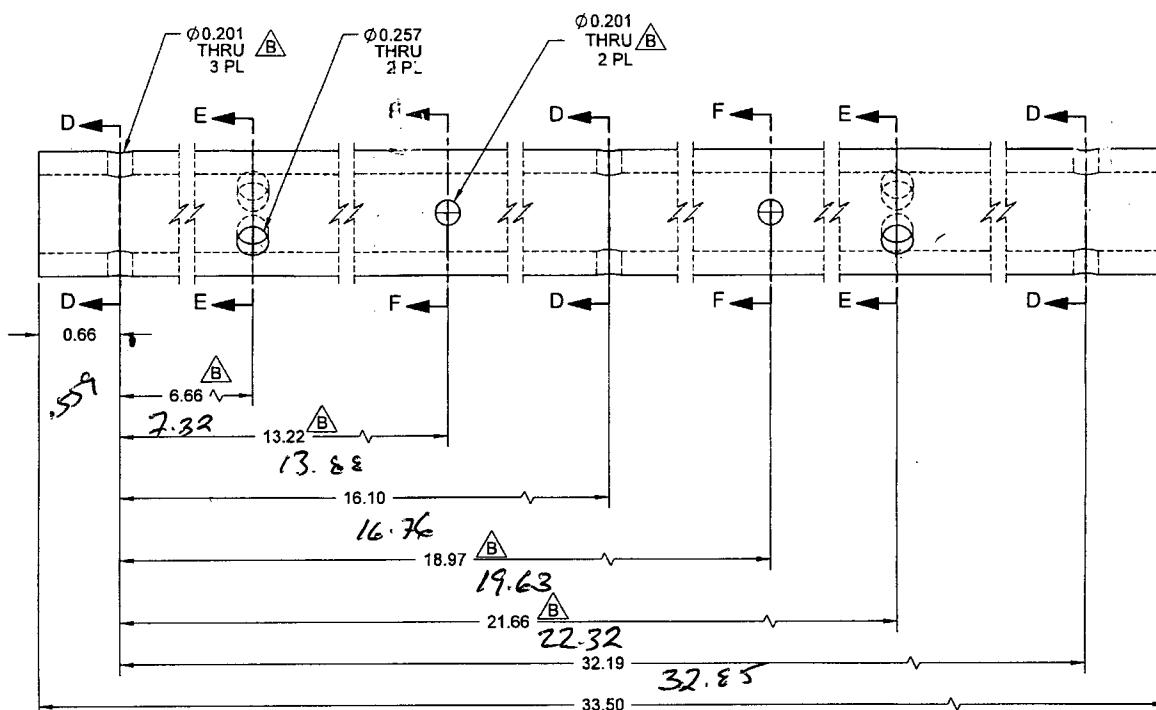
SECTION D-D



SECTION E-E



SECTION F-F



D3766-2 FRONT RAIL, RH

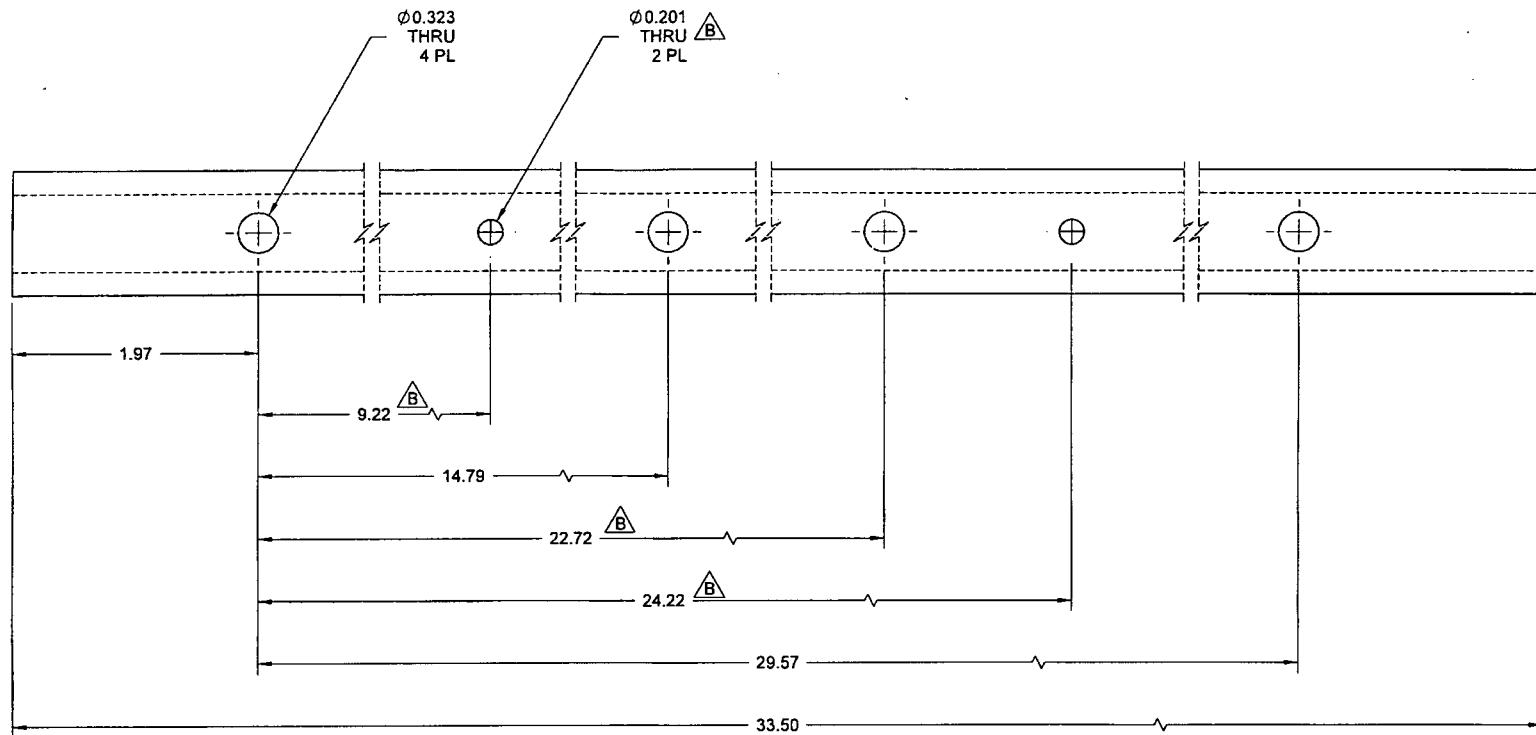
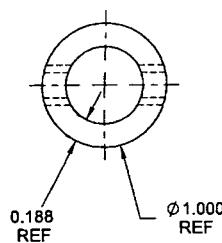
W/0 54382

08.07.10 THP

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8 7 6 5 4 3 2 1



D3766-3 REAR RAIL

W/0 5438 06-07-10 MP

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DE APPR.		DATE 08.06.10	

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8 7 6 5 4 3 2 1

D

C

B

A